

Work Order ID 85109

Friday, July 06, 2012 1:36:51 PM

85109**DUPLICATE**

Page 1

Item ID: PB67-43001-07

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Fwd Blade Fold Assembly Weldment

Start Date: 6/1/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

*could not find original w/o*Approvals: Process Plan: *UMF*Date: *12-07-06*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

B67-43001-07

Rev C

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble parts on jig DT8813 and weld as per dwg PB67-43001*** ensure no burn thru after welding in tube -205 and -197 only where bushing -265 ***

1 d BE 12-07-09

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

1 d BE 12-07-09

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

8/12/10/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85109

Friday, July 06, 2012 1:36:51 PM

85109

Page 2

Item ID: PB67-43001-07

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Blade Fold Assembly Weldment

Start Date: 6/1/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

130

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

130

Powdercoat

Memo

0.00 / 8.44

Powder Coating

***mask inside of D3440-5, D3440-7 and D3440-15 prior to

paint***START TIME:

TEMPERATURE: 320° FINISH TIME: 9:30

1 of 1279

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

1 of 11076

150

Identify as per dwg & Stock Location: _____

0.00

150

Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85109***85109***

Page 3

Friday, July 06, 2012 1:36:51 PM

Item ID: PB67-43001-07

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Blade Fold Assembly Weldment

Start Date: 6/1/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

CK 12/7/10

MF
12-07-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, July 06, 2012 1:36:50 PM

Page 1
13

Work Order ID: 85109
Parent Item: PB67-43001-07
Parent Item Name: Fwd Blade Fold Assembly Weldment

Start Date: 6/1/2012 Required Date: 6/29/2012
Start Qty: 1.00 Required Qty: 1.00

Comments: IPP Rev:A 08-06-25 new issue DD verified by:ec IPP rev B 10.09.24 per revC
dwg EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-47 Base Assembly		Manufactured	No			100	Each	1.0000	1	1		12.07.09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		1							
				85183		1							
PB67-43001-197 Outer Tube		Manufactured	No			100	Each	1.0000	1	1		12.07.09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST446		1							
				85182		1							
PB67-43001-199 Outer Tube End Cap		Manufactured	No			100	Each	19.0000		2		12.07.09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz		19							
				44991		19							
PB67-43001-201 Square Tube		Manufactured	No			100	Each	2.0000	1	1		12.07.09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST437		2							
				62104		2							
PB67-43001-203 Square Tube		Manufactured	No			100	Each	5.0000	1	1		12.07.09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST437		5							
				62105		5							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, July 06, 2012 1:36:50 PM

Page 2

Work Order ID: 85109

Parent Item: PB67-43001-07

Parent Item Name: Fwd Blade Fold Assembly Weldment

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-105 Manufactured No 100 Each 1.0000 1 1

Outer Tube

Location

Loc Qty

Loc Code

ST446

1

85180

1

PB67-43001-207 Manufactured No 100 Each 0.0000 1

Square Tube

PB67-43001-209 Manufactured No 100 Each 0.0000 1

Square Tube

PB67-43001-211 Manufactured No 100 Each 2.0000 6

Square Tube

Location

Loc Qty

Loc Code

WA

2

85179

2

PB67-43001-219 Manufactured No 100 Each 6.0000 1 1

Angled Male Eye

Location

Loc Qty

Loc Code

ST438

6

52606

6

PB67-43001-223 Manufactured No 100 Each 43.0000 1 1

Square Cap

Location

Loc Qty

Loc Code

Mezz

43

47504

43

PB67-43001-225 Manufactured No 100 Each 29.0000 4

Bushing

Location

Loc Qty

Loc Code

Mezz

29

44988

29

Friday, July 06, 2012 1:36:50 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, July 06, 2012 1:36:50 PM

Page 3

Work Order ID: 85109

Parent Item: PB67-43001-07

Parent Item Name: Fwd Blade Fold Assembly Weldment

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-227 Manufactured No
Bushing

100 Each 33.0000

2

12.07.09

Location

Loc Qty

Loc Code

ST438

33

2

31

43712

44987

D3440-7 Manufactured No
Detent Clip Base (Supersedes B67-43001-221)

100 Each 0.0000

1

12 1 41455 12.07.09

D3440-5 Manufactured No
Contoured Detent Clip Base (Supersedes B67-43001-217)

100 Each 0.0000

1

1 x 1 41454 12.07.09

D3440-15 Manufactured No
Contoured Male Eye (Supersedes B67-43001-215)

100 Each 3.0000

1

1 12.07.09

Location

Loc Qty

Loc Code

ST439A

3

3

62186

x 1

Friday, July 06, 2012 1:36:51 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

LOT TRACKING !!

Parent Item ID	Reason	Lot Qty	Lot Nbr	Lot Trans Date
PB67-43001-209	85109	-1	52485	6/19/2012 1:02:58 PM
PB67-43001-211	85109	-6	62106	6/19/2012 1:02:58 PM
PB67-43001-227	85109	-2	43712	6/19/2012 1:02:58 PM
PB67-43001-203	85109	-1	62105	6/19/2012 11:45:57 AM
PB67-43001-207	85109	-1	52604	6/19/2012 1:00:30 PM
D3440-7	85109	-1	41455	6/19/2012 1:02:58 PM
D3440-5	85109	-1	41454	6/19/2012 1:02:58 PM
D3440-15	85109	-1	62186	6/19/2012 1:02:58 PM
PB67-43001-219	85109	-1	52606	6/19/2012 1:02:58 PM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries